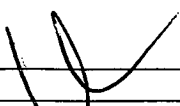
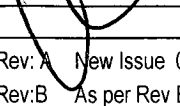


Date: Thursday, 13/09/2007 11:08:31 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DUMP OUTLET
Job Number	: 34654		
Estimate Number	: 12166		
P.O. Number	: N/A	Part Number	: D3475041
This Issue	: 13/09/2007	Drawing Number	: D3475 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: B
Previous Run	: 28544	Material	: N/A
Written By	: 	Due Date	: 20/09/2007
Checked & Approved By	: 	Qty:	6
Comment	Est Rev: A New Issue 06-02-03 JLM Est Rev: B As per Rev B 06-05-24 JLM		
Um:	Each		

Additional Product

Job Number:



Seq. #: **Machine Or Operation:** **Description :**

1.0 D34753 TUBE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3475-1	Tube	B 34394

D3475-3

2.0 D34751 OUTLET ADAPTER PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3475-1	Flange	B 34393

3.0 NAS1031C3W Nutplate



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s) 40

Pick:

Qty	Part Number	Description	Batch
8	NAS1031C3W	Nut Plate	M105569 x 25
			M105559 x 15

25
✓ m/07/09/13

4.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

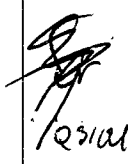
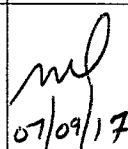

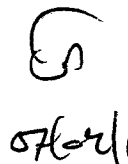



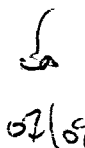
1-Assemble as per Dwg D3479

PTD

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/09/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/09/17	4	Bad Assy when welding	 J. Smith	one D3475-041 No good Scrap it and No replace	 J. Smith 07/09/17	En Atollig 07/09/18	 J. Smith 07/09/18	 J. Smith 07/09/18
07/09/18	4 y.10	Parts are too long by 0.0004	 J. Smith	Parts are acceptable	 J. Smith 07/09/18	En 07/09/18	 J. Smith 07/09/18	 J. Smith 07/09/18

NOTE: Date & initial all entries

Date: Thursday, 13/09/2007 11:08:31 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DUMP OUTLET

Job Number: 34654

Part Number: D3475041

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Spot Weld as per Dwg D3475 and Dart QSI 018

ml 07/09/17 (X5)

5.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/09/17 (5)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/09/18 (X5)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock

Location: _____

07/09/18 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/09/19 (5)

Job Completion



U 07-09-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

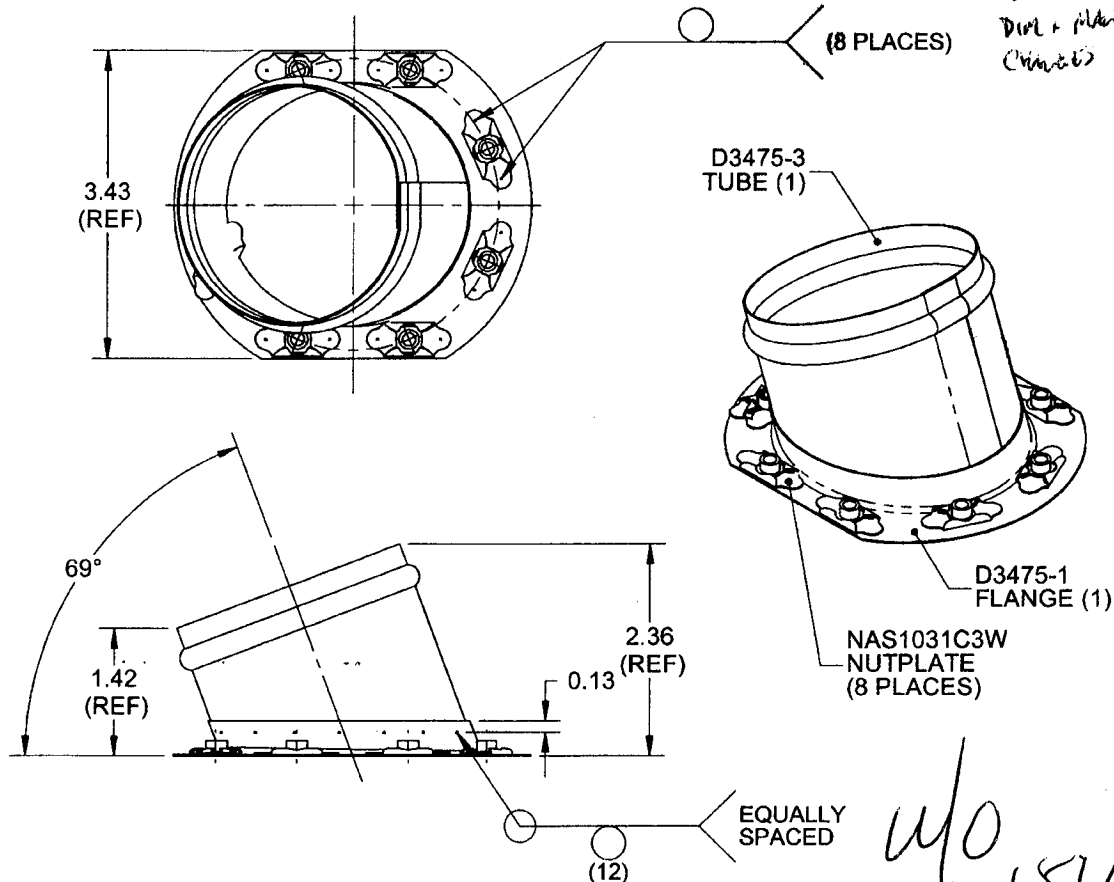
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART**RELEASED**
06-05-16

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 13	APPROVED 13	DRAWING NO. D3475	REV. B SHEET 1 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:2
A	06.01.24	NEW ISSUE	
B	06.05.16	REDESIGN D3475-1F/-5/-7S/-7; ADD D3475-9	

**D3475-041 DUMP OUTLET****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) IDENTIFY WITH DART P/N D3475-041 USING FINE POINT PERMANENT INK MARKER
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3475-041	DUMP OUTLET
1	D3475-1	FLANGE
1	D3475-3	TUBE
8	NAS1031C3W	NUTPLATE

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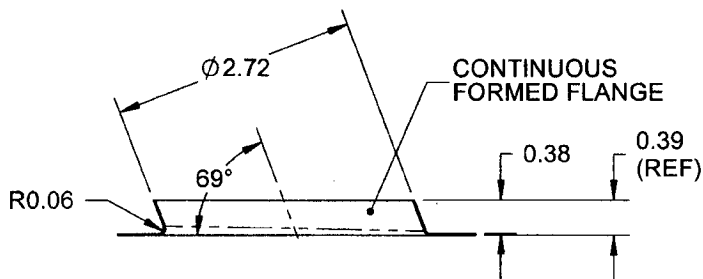
775

DESIGN 13	DRAWN BY 13	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3475	REV. B SHEET 2 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:2

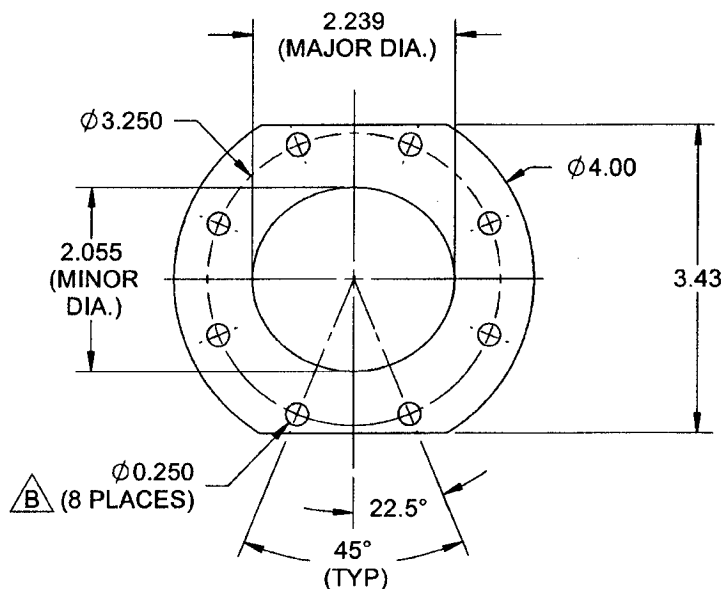
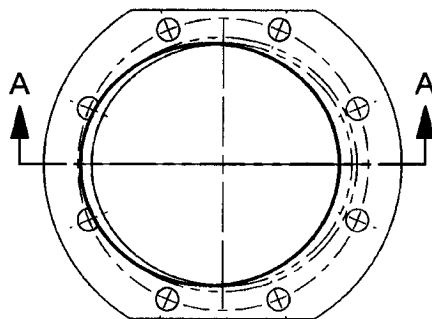
RELEASED
06-05-16

UNDER REVIEW

Dist + Manufacturing
Credits



SECTION A-A



D3475-1 OUTLET ADAPTER PLATE

D3475-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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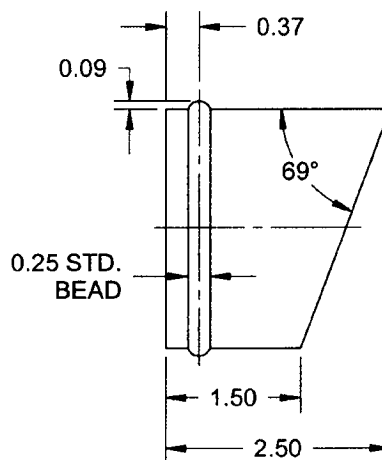
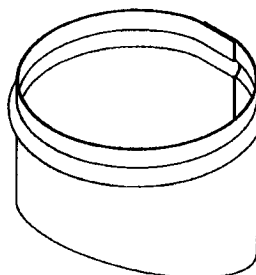
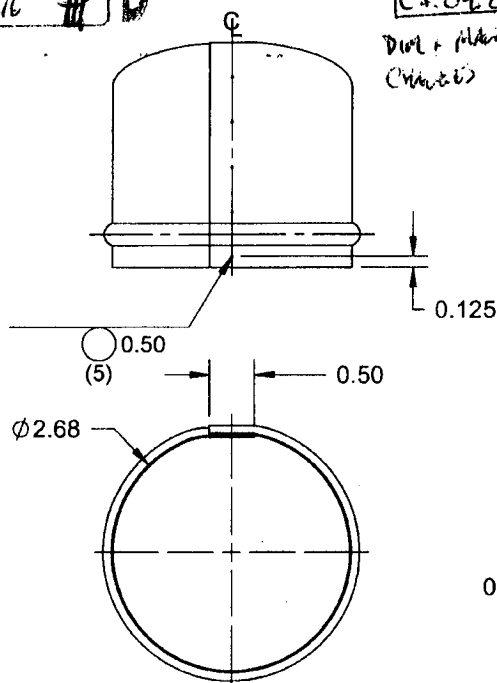
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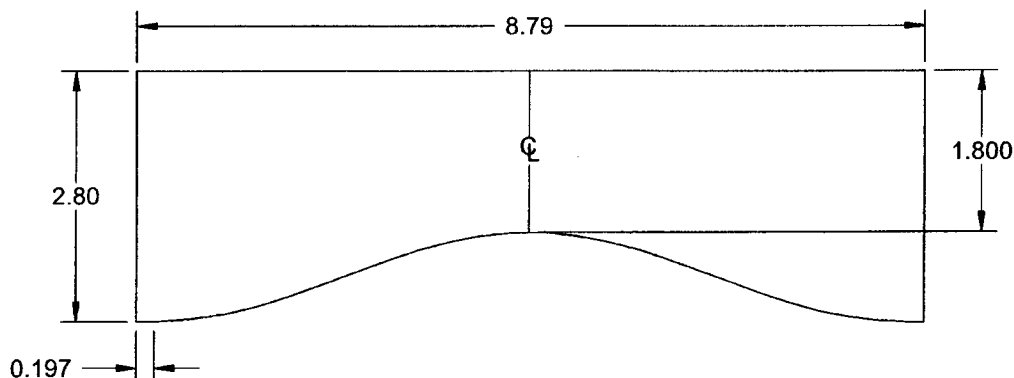
DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3475	REV. B SHEET 3 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:2

RELEASED
06.05.16 *#*

UNDER REVIEW
02.09.16 *B*
Dim + planification
(Chute)



D3475-3 TUBE



D3475-3F TUBE FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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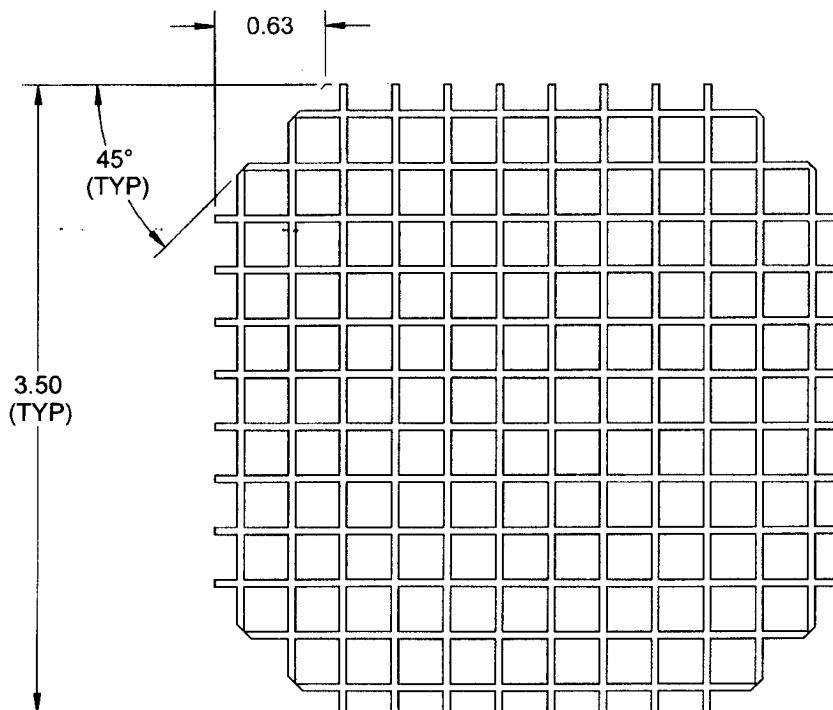


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3475	REV. B SHEET 4 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:1

UNDER REVIEW

02.09.16
Dirt + Abrasive
Chamber

RELEASED
06.05.16



D3475-5 SCREEN

NOTES:

- 1) MATERIAL: #4 MESH SCREEN, 0.203" OPENING, ϕ 0.047" WIRE
(REF. DART SPEC. M304MS4.203-.047)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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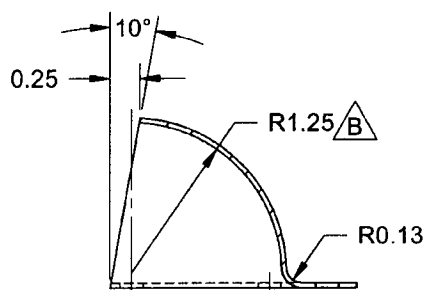
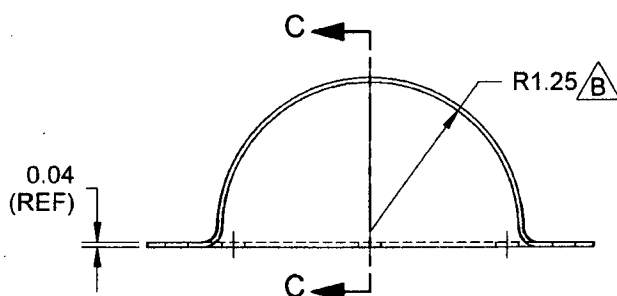
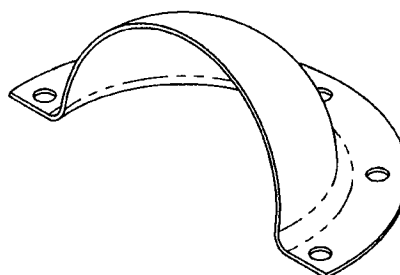
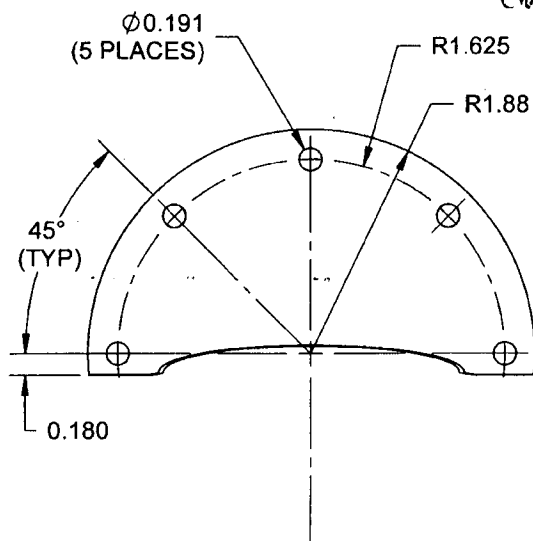


DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3475	REV. B SHEET 6 OF 7
DATE 06.05.16		TITLE DUMP OUTLET	SCALE 1:1.5

UNDER REVIEW

02.04.03
Dial + planification
06.05.16

RELEASED
06.05.16



SECTION C-C

D3475-7 SCOOP OUTLET

NOTES:

- 1) MATERIAL: MAKE FROM D3475-7S
- 2) IDENTIFY WITH DART P/N D3475-7 USING FINE POINT PERMANENT INK MARKER
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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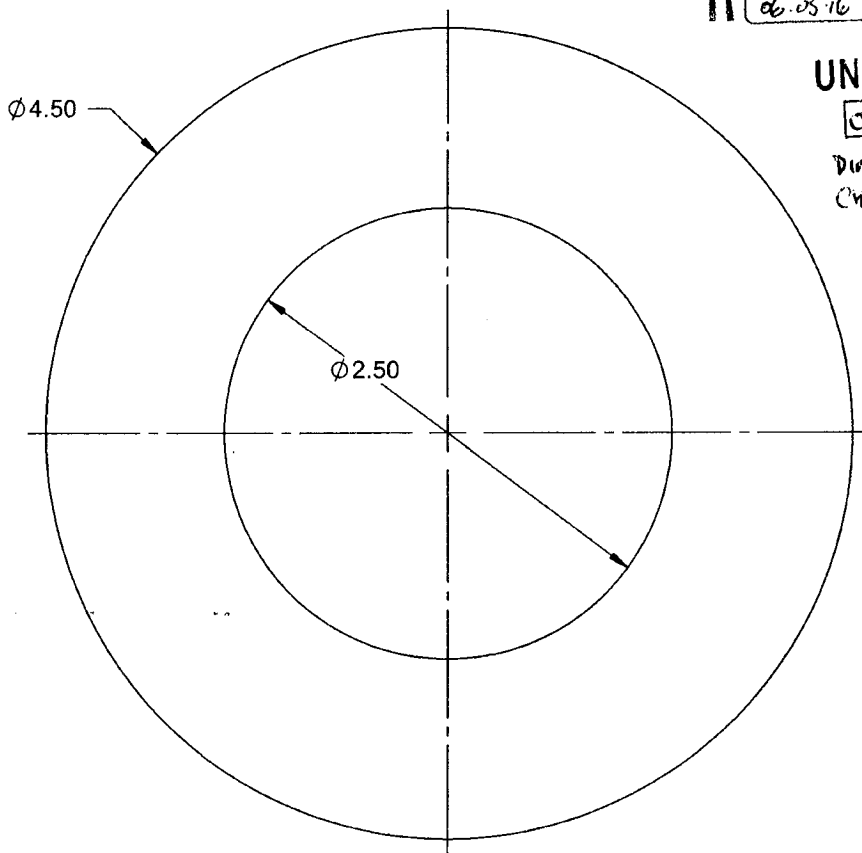
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3475	REV. B SHEET 7 OF 7
DATE 06.05.16		TITLE DUMP OUTLET SCALE 1:1	

RELEASED
[Signature] 06.05.16

UNDER REVIEW

[Signature] 02.09.16

*Dipl + Manufacturing
(Virtu)*



D3475-9 OUTLET GASKET

NOTES:

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 15

EMPLOYEE: Monique hepcie

PART NUMBER: D3475-041

JOB NUMBER: B 34654

MATERIAL TYPE: 304 L

MATERIAL THICKNESS: .078

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium

TEST RESULTS

	PASS	FAIL
VISUAL:	[/]	[]
PENETRATION:	[/]	[]
PULL STRENGTH:	[/]	[] PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/09/17

QUALIFIER: SD